

Work Order ID 154517

Thursday, December 15, 2016 8:00:40 AM

154517

Page 1

Item ID: D4062-041 Accept ***N900040100*** Setup Start ***NS1***
Revision ID: Stop ***NS2***
Item Name: Tank Support Assembly
Start Date: 12/23/2016 Start Qty: 4.00 ***4*** Cust Item ID:
Required Date: 1/9/2017 Req'd Qty: 4.00 ***4*** Customer:
Reference:

Approvals: Process Plan: DAS 21 Date: DEC 15 2016 Tooling: _____ Date: _____ Run Start ***NR1***
QC: 9-89 Date: _____ SPC (Y/N): _____ Date: _____ Stop ***NR2***

Sequence ID/ Work Center ID	Operation Description	Set Up/ Run Hours	Tool ID	Tool #	Plan Code	Accept Qty	Reject Qty	Reject Number	Insp. Stamp
Draw Nbr	Revision Nbr								
D4062	E								
100		0.00							
100									
Waterjet	Memo	0.35							
FLOW CNC Waterjet	CUT BLANK AS PER FILE D4062-1_BLANK								
102	QC2- Inspect parts off machine FAI/FAIB	0.00							
102									
QC	Memo	0.01							
Quality Control									
105		0.40							
105									
HAAS 1	Memo	0.23							
HAAS CNC vertical machine #1	MILL AS PER DWG AND FOLIO FA949 DWG REV: <u>5</u> FOLIO REV: <u>AN</u>								

(4) _____ on 12/12/19

4 Ø _____ man L
17/01/11

4 Ø _____ DAS 49
9-89
17/01/20

DQA: _____ Date: _____



WORK ORDER NON-CONFORMANCE / UPDATE

QA Closed: _____ Date: _____

Work Order update only ☐

Work Order: _____ Part No. _____ NCR No. _____		DISPOSITION Rework ☐ Scrap ☐ Use-as-is ☐ Suspected Unapproved ☐		AGAINST DEPARTMENT/PROCESS Skid-tube ☐ Machining ☐ Thermoforming ☐ Large Fab ☐ Cross tube ☐ Small Fab ☐ Finishing ☐ Composite ☐ Water Jet ☐ Prod. Eng. Coord. ☐ Rec/Store/Packaging ☐ Supplier ☐ Engineering ☐ Quality ☐ Other ☐					
Date :		Step #:		QTY Effective :			MRB (QSI042) Approval Completed By Lead hand / Supervisor Approval Verification QC / QA Coordinator Approval		
Description Work Order Deviation				Disposition					
Root Cause Environment ☐ Design ☐ Doc/Data ☐ Equip/Tooling ☐ Handling/Pre ☐ Material ☐ Internal Transport ☐ Tribal Knowledge ☐ LOA ☐ Substation ☐ Past Expiry Date ☐ Misidentified ☐ No Re-verification ☐ Operator ☐ Offset/Setup ☐ Supplier ☐ Training ☐ Use for Testing ☐ Poor Information ☐ Rushing ☐ Product Improvement ☐ Process Improvement ☐ Manufacturing Process ☐ Past Due ☐		FAULT CATEGORY Pressure/Forced ☐ Bending ☐ Centre Not Concentric ☐ Cracks ☐ Crimp/Kink/Ripple/Wave ☐ Cuffs ☐ Crushing ☐ Heat Treat ☐ Wave/Twist in Tube ☐ Marks/Chatter ☐ Temperature/Cure ☐ Set-up ☐ BOM/Route ☐ Broken/Damage/Defect ☐ Inspection Incomplete/Unqualified ☐ Contamination ☐ Countersink ☐ Cut Too Short ☐ Instructions Incomplete/Unclear ☐ Drill Holes ☐ Power Loss/Surge ☐ Folio/Program ☐ Grain ☐ Weld ☐ Wrong Stock Pulled ☐ Out of Sequence ☐ Off-set ☐ Mislabeled ☐ Fit/Function ☐ Misaligned/off center ☐ Positioned Wrong ☐ Outside Dimensions ☐ Over/Under tolerance ☐ Part Incorrect ☐ Part Lost/Missing ☐ Part Moved ☐ Drawing ☐ Finish ☐ Misread ☐ Turning Sequence ☐		OTHER : _____					

Work Order ID 154517***154517***

Page 2

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Item ID: D4062-041

Accept

N900040100

Setup Start

NS1

Revision ID:

Stop

NS2

Item Name: Tank Support Assembly

Start Date: 12/23/2016 Start Qty: 4.00

4

Cust Item ID:

Required Date: 1/9/2017 Req'd Qty: 4.00

4

Customer:

Reference:

Approvals:

Process Plan: _____

Date: _____

Tooling: _____

Date: _____

Run Start

NR1

QC: _____

Date: _____

SPC (Y/N): _____

Date: _____

Stop

NR2Sequence ID/
Work Center IDOperation
DescriptionSet Up/
Run Hours

Tool ID

Tool #

Plan
CodeAccept
QtyReject
QtyReject
NumberInsp.
Stamp

106

QC2- Inspect parts off machine FAI/FAIB

0.00

106

QC

Memo

0.01

Quality Control

4

0

DAS
49
9-89

17/01/20

130

QC8- Inspect parts - second check

0.00

130

QC

Memo

0.01

Quality Control

4

0

DAS
33
9-89

17/01/21

140

Identify as per dwg & Stock Location: _____

0.00

140

Packaging

Memo

0.01

Packaging

LOCATION: WA003

4

DAS
6
9-89

JAN 23 2017

DQA: _____ Date: _____



WORK ORDER NON-CONFORMANCE / UPDATE

QA Closed: _____ Date: _____

Work Order update only ☐

Work Order: _____ Part No. _____ NCR No. _____		DISPOSITION Rework ☐ Scrap ☐ Use-as-is ☐ Suspected Unapproved ☐		AGAINST DEPARTMENT/PROCESS <table style="width:100%; border: none;"> <tr> <td style="width:15%;">Skid-tube ☐</td> <td style="width:15%;">Cross tube ☐</td> <td style="width:15%;">Water Jet ☐</td> <td style="width:15%;">Engineering ☐</td> </tr> <tr> <td>Machining ☐</td> <td>Small Fab ☐</td> <td>Prod. Eng. Coord. ☐</td> <td>Quality ☐</td> </tr> <tr> <td>Thermoforming ☐</td> <td>Finishing ☐</td> <td>Rec/Store/Packaging ☐</td> <td>Other ☐</td> </tr> <tr> <td>Large Fab ☐</td> <td>Composite ☐</td> <td>Supplier ☐</td> <td></td> </tr> </table>						Skid-tube ☐	Cross tube ☐	Water Jet ☐	Engineering ☐	Machining ☐	Small Fab ☐	Prod. Eng. Coord. ☐	Quality ☐	Thermoforming ☐	Finishing ☐	Rec/Store/Packaging ☐	Other ☐	Large Fab ☐	Composite ☐	Supplier ☐	
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Sequence ID/ Work Center ID	Operation Description	Set Up/ Run Hours	Tool ID	Tool #	Plan Code	Accept Qty	Reject Qty	Reject Number	Insp. Stamp
150	QC21- Final Inspection - Work Order Release	0.00					DAS 21 9-89		JAN 2 4 2017
150									
QC	Memo	0.07							
Quality Control									

DAS
21
9-89

JAN 2 3 2017

DQA: _____ Date: _____



WORK ORDER NON-CONFORMANCE / UPDATE

QA Closed: _____ Date: _____

Work Order update only ☐

Work Order: _____ Part No. _____ NCR No. _____	DISPOSITION Rework ☐ Scrap ☐ Use-as-is ☐ Suspected Unapproved ☐	AGAINST DEPARTMENT/PROCESS Skid-tube ☐ Machining ☐ Thermoforming ☐ Large Fab ☐ Cross tube ☐ Small Fab ☐ Finishing ☐ Composite ☐ Water Jet ☐ Prod. Eng. Coord. ☐ Rec/Store/Packaging ☐ Supplier ☐ Engineering ☐ Quality ☐ Other ☐									
Date : _____	Step #: _____	QTY Effective : _____		MRB (QSI042) Approval Completed By Lead hand / Supervisor Approval Verification QC / QA Coordinator Approval							
Description Work Order Deviation		Disposition									
Root Cause <table style="width:100%; border-collapse: collapse;"> <tr> <td style="width:50%; vertical-align: top;"> Environment ☐ Design ☐ Doc/Data ☐ Equip/Tooling ☐ Handling/Pre ☐ Material ☐ Internal Transport ☐ Tribal Knowledge ☐ LOA ☐ Substation ☐ Past Expiry Date ☐ Misidentified ☐ </td> <td style="width:50%; vertical-align: top;"> No Re-verification ☐ Operator ☐ Offset/Setup ☐ Supplier ☐ Training ☐ Use for Testing ☐ Poor Information ☐ Rushing ☐ Product Improvement ☐ Process Improvement ☐ Manufacturing Process ☐ Past Due ☐ </td> </tr> </table>		Environment ☐ Design ☐ Doc/Data ☐ Equip/Tooling ☐ Handling/Pre ☐ Material ☐ Internal Transport ☐ Tribal Knowledge ☐ LOA ☐ Substation ☐ Past Expiry Date ☐ Misidentified ☐	No Re-verification ☐ Operator ☐ Offset/Setup ☐ Supplier ☐ Training ☐ Use for Testing ☐ Poor Information ☐ Rushing ☐ Product Improvement ☐ Process Improvement ☐ Manufacturing Process ☐ Past Due ☐	FAULT CATEGORY <table style="width:100%; border-collapse: collapse;"> <tr> <td style="width:33%; vertical-align: top;"> Pressure/Forced ☐ Bending ☐ Centre Not Concentric ☐ Cracks ☐ Crimp/Kink/Ripple/Wave ☐ Cuffs ☐ Crushing ☐ Heat Treat ☐ Wave/Twist in Tube ☐ Marks/Chatter ☐ </td> <td style="width:33%; vertical-align: top;"> Temperature/Cure ☐ Set-up ☐ BOM/Route ☐ Broken/Damage/Defect ☐ Inspection Incomplete/Unqualified ☐ Contamination ☐ Countersink ☐ Cut Too Short ☐ Instructions Incomplete/Unclear ☐ Drill Holes ☐ </td> <td style="width:33%; vertical-align: top;"> Power Loss/Surge ☐ Folio/Program ☐ Grain ☐ Weld ☐ Wrong Stock Pulled ☐ Out of Sequence ☐ Off-set ☐ Misabeled ☐ Fit/Function ☐ Misaligned/off center ☐ </td> <td style="width:33%; vertical-align: top;"> Positioned Wrong ☐ Outside Dimensions ☐ Over/Under tolerance ☐ Part Incorrect ☐ Part Lost/Missing ☐ Part Moved ☐ Drawing ☐ Finish ☐ Misread ☐ Turning Sequence ☐ </td> </tr> </table>				Pressure/Forced ☐ Bending ☐ Centre Not Concentric ☐ Cracks ☐ Crimp/Kink/Ripple/Wave ☐ Cuffs ☐ Crushing ☐ Heat Treat ☐ Wave/Twist in Tube ☐ Marks/Chatter ☐	Temperature/Cure ☐ Set-up ☐ BOM/Route ☐ Broken/Damage/Defect ☐ Inspection Incomplete/Unqualified ☐ Contamination ☐ Countersink ☐ Cut Too Short ☐ Instructions Incomplete/Unclear ☐ Drill Holes ☐	Power Loss/Surge ☐ Folio/Program ☐ Grain ☐ Weld ☐ Wrong Stock Pulled ☐ Out of Sequence ☐ Off-set ☐ Misabeled ☐ Fit/Function ☐ Misaligned/off center ☐	Positioned Wrong ☐ Outside Dimensions ☐ Over/Under tolerance ☐ Part Incorrect ☐ Part Lost/Missing ☐ Part Moved ☐ Drawing ☐ Finish ☐ Misread ☐ Turning Sequence ☐
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		OTHER : _____									

Picklist Print

Thursday, December 15, 2016 8:00:40 AM

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Work Order ID: 154517

154517

Parent Item: D4062-041

D4062-041

Parent Item Name: Tank Support Assembly

Start Date: 12/23/2016

Required Date: 1/9/2017

Start Qty: 4.00

Required Qty: 4.00

Comments: IPP REV:A NEW ISSUE 11-11-23 JLM VERIFIED BY:DD IPP
REV:B AS PER REV C 12-03-08 JLM VERIFIED BY:DD IPP REV:C
AS PER REV D 13-07-16 JLM VERIFIED BY:DD

Component Item ID/ Item Name	Replacement Item ID	Mfg/ Purch	Bin Item	Primary Location	Last Location	Route Seq ID	Unit of Measure	Qty on Hand	Qty per Kit	Total Qty	Qty Issued	Date Issued	Status
---------------------------------	------------------------	---------------	-------------	---------------------	------------------	-----------------	--------------------	----------------	-------------	--------------	---------------	----------------	--------

MUHMWB1.250

Purchased

No

sf

55.5000

15.34737

MUHMWB1 250

m 12/12/19

UHMWB 1.250 BLACK

Location

Loc Qty

Loc Code

MAT019

55.5

m127198

55.5

16

DQA: _____ Date: _____



WORK ORDER NON-CONFORMANCE / UPDATE

QA Closed: _____ Date: _____

Work Order update only ☐

Work Order: _____ Part No. _____ NCR No. _____		DISPOSITION Rework ☐ Scrap ☐ Use-as-is ☐ Suspected Unapproved ☐		AGAINST DEPARTMENT/PROCESS Skid-tube ☐ Machining ☐ Thermoforming ☐ Large Fab ☐ Cross tube ☐ Small Fab ☐ Finishing ☐ Composite ☐ Water Jet ☐ Prod. Eng. Coord. ☐ Rec/Store/Packaging ☐ Supplier ☐ Engineering ☐ Quality ☐ Other ☐					
Date :		Step #:		QTY Effective :			MRB (QSI042) Approval Completed By Lead hand / Supervisor Approval Verification QC / QA Coordinator Approval		
Description Work Order Deviation				Disposition					

Root Cause				FAULT CATEGORY			
Environment	☐	No Re-verification	☐	Pressure/Forced	☐	Temperature/Cure	☐
Design	☐	Operator	☐	Bending	☐	Set-up	☐
Doc/Data	☐	Offset/Setup	☐	Centre Not Concentric	☐	BOM/Route	☐
Equip/Tooling	☐	Supplier	☐	Cracks	☐	Broken/Damage/Defect	☐
Handling/Pre	☐	Training	☐	Crimp/Kink/Ripple/Wave	☐	Inspection Incomplete/Unqualified	☐
Material	☐	Use for Testing	☐	Cuffs	☐	Contamination	☐
Internal Transport	☐	Poor Information	☐	Crushing	☐	Countersink	☐
Tribal Knowledge	☐	Rushing	☐	Heat Treat	☐	Cut Too Short	☐
LOA	☐	Product Improvement	☐	Wave/Twist in Tube	☐	Instructions Incomplete/Unclear	☐
Substation	☐	Process Improvement	☐	Marks/Chatter	☐	Drill Holes	☐
Past Expiry Date	☐	Manufacturing Process	☐	OTHER : _____			
Misidentified	☐	Past Due	☐				

DART AEROSPACE LTD		Work Order:	154577
Description: Tank Support Assembly		Part Number:	D4062-041
Inspection Dwg: D4062	Rev: E	Page 1 of 1	

INSPECTION SHEET

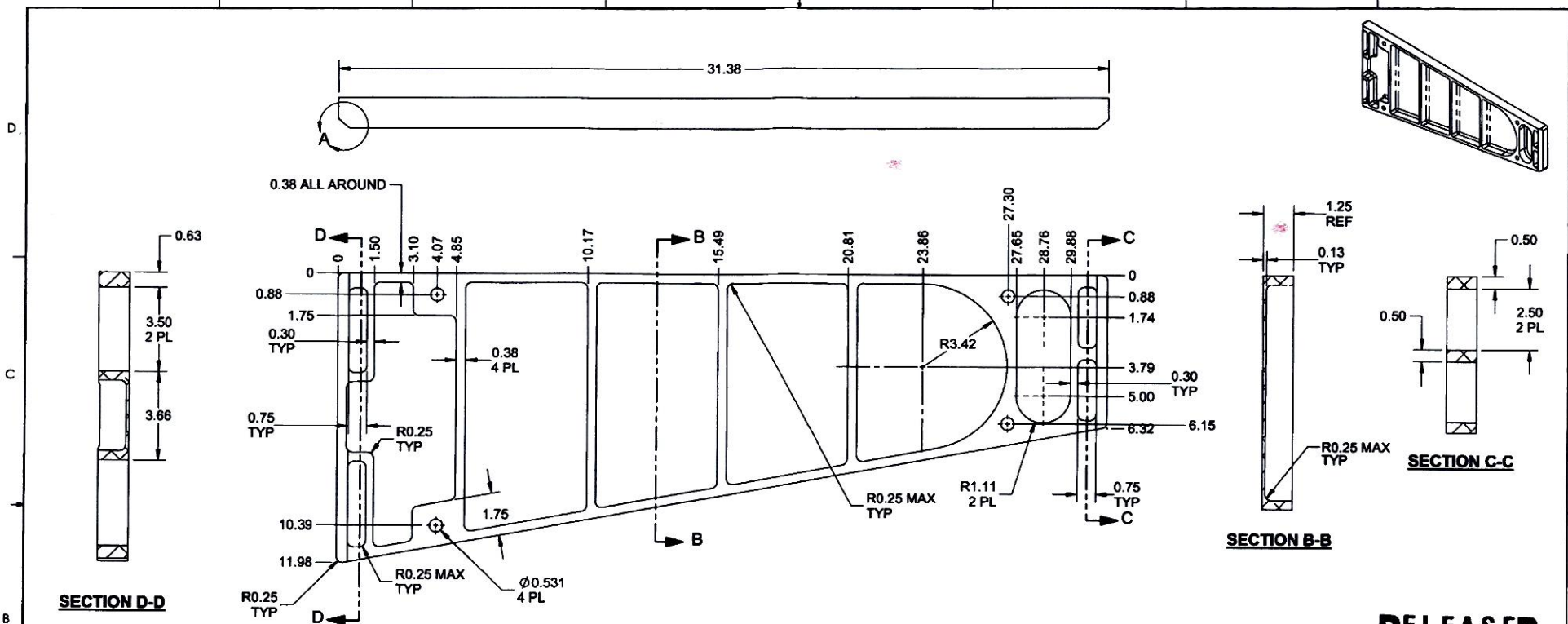
Drawing Dimension	Tolerance	Actual Dimension	Accept	Reject	Method of Inspection	Comments
31.38	+/-0.030	31.375	/		tape	
0.63	+/-0.030	0.615	/		vern	mm L-OS
3.50	+/-0.030	3.493	✓		"	
3.66	+/-0.030	3.653	/		"	
11.98	+/-0.030	11.98	/		tape	
1.50	+/-0.030	1.495	/		vern	mm L-OS
3.10	+/-0.030	3.105	/		"	
4.85	+/-0.030	4.840	/		"	
10.17	+/-0.030	10.170	/		tape	
15.49	+/-0.030	15.490	/		"	
20.81	+/-0.030	20.810	/		"	
27.65	+/-0.030	27.65	/		"	
29.88	+/-0.030	29.88	/		"	
0.75	+/-0.030	0.745	/		vern	mm L-OS
0.38	+/-0.030	0.377	/		"	
1.75	+/-0.030	1.749	/		"	
1.75	+/-0.030	1.749	/		"	
Ø0.531	+0.008/-0.001	0.532	/		"	
0.88	+/-0.030	0.872	✓		"	
4.07	+/-0.030	4.067	/		"	
27.30	+/-0.030	27.30	✓		tape	
10.39	+/-0.030	10.383	✓		vern	mm L-OS
6.15	+/-0.030	6.153	✓		"	
R1.11	+/-0.030	1.11	✓		R.G	
R0.250	+/-0.010	.250	/		"	
R0.250	+/-0.010	.250	/		"	
1.25	+/-0.030	1.259	✓		vern	mm L-OS
0.13	+/-0.030	0.143	✓		Height	31006
0.50	+/-0.030	.493	✓		vern	mm L-OS
0.50	+/-0.030	.502	/		"	
2.50	+/-0.030	2.499	/		"	
0.375 x 50°	+/-0.010 x +/-0.5°	0.365 x 50°	✓		"	

Measured by:	49 9-89	Checked by:	33 9-89	QC Inspector:	
Date:	17/01/20	Date:	17/01/21	Date:	

Engineering Approval: (If necessary)		Date:	
--	--	--------------	--

Rev	Date	Change	Revised by	Approved
A	15.09.23	New Issue	KJ	

8 7 6 5 4 3 2 1



SECTION D-D

SECTION B-B

SECTION C-C

DETAIL A
2 PL

D4062-041 TANK SUPPORT ASSEMBLY

RELEASED
2015-06-16
EN 15-583

SHOP COPY
RETURN TO
ENGINEERING
UNCONTROLLED COPY
SUBJECT TO AMENDMENT
WITHOUT NOTICE
WORK ORDER
NO. 154517 NLS
1612-05

- NOTES:**
- 1) MATERIAL: BLACK UHMW TIVAR 1000 VIRGIN MATERIAL SHEET, 1.25 THICK
REF DART SPEC MUHMB125
 - 2) FINISH: N/A
 - 3) TOLERANCES: PER DART QSI 018 UNLESS OTHERWISE NOTED
 - 4) UNITS: INCHES UNLESS OTHERWISE NOTED
 - 5) BREAK SHARP EDGES: 0.005 TO 0.010 MAX
 - 6) IDENTIFICATION: N/A
 - 7) WEIGHT: 3.56 lbs

REV.	DESCRIPTION	BY	DATE
E	MODIFIED -041. ADDED DETAIL A. ZN A8-1. SECTION C-C BECOMES SECTION B-B. ADDED NEW SECTION C-C, AND SECTION D-D.	CC	15.02.06
D	MODIFIED -041, REMOVED -1/-3. 23.78 DIM CORRECTED, ZN B5-1.	DC	13.06.24
C	REMOVE HARDWARE TO ATTACH ITEMS 2 & 3. REMOVE CBORE.	DC	11.12.14
B	MODIFIED DIMS & DESIGN OF -1, ADDED -3/-041	DC	11.09.29
A	NEW ISSUE	HS	10.07.26
DESIGN	HS	DART AEROSPACE LTD HAWKESBURY, ONTARIO, CANADA DRAWING NO. D4062 TANK SUPPORT COPYRIGHT © 2018 BY DART AEROSPACE LTD THIS DOCUMENT IS PRIVATE AND CONFIDENTIAL AND IS SUPPLIED ON THE EXPRESS CONDITION THAT IT IS NOT TO BE USED FOR ANY PURPOSE OR COPIED OR COMMUNICATED TO ANY OTHER PERSON WITHOUT WRITTEN PERMISSION FROM DART AEROSPACE LTD.	
DRAWN	CC		
CHECKED	VS		
MFG. APPR.	JLM		
APPROVED	HS		
DE APPR.	DS	REV. E	SHEET 1 OF 1
DATE	15.02.06	SCALE	NTS

APPROVED



Preventive Action Report

Reviewed			
DQA:		Printed on: Wednesday, May 11, 2016	
Date:			
Details			
Raised Date 9/17/2015	Status Open	Owner Monterroza, William	Number PAR15-459
Target Date 12/4/2015	Standard	Severity MINOR	
Process Employee finding		Audit	
Raised By Person Menard, Jean-Luc	Raised Against (Department or Supplier) Engineering		Fault Category General\Drawing
Details There seems to be a discrepancy between the model and dwg (dwg should be .375" instead of .300) That difference is not significant for on-going production but we need to update the drawing (attached)			
Keywords		Product D4062 rev C	
Document		Root Cause Data/Documentation	
Closed By	Closed Date	Resolution	
Corrective Action			
Target Date 11/27/2015	Owner Monterroza, William	Closed Date 5/10/2016	Closed By Bain, David
Details <i>Assign DART minor change officer to create a DED for this</i>			
Actions			
Number	Owner	Target Date	Completed Date
Details		Response	
1	Bain, David	5/18/2016	5/10/2016
Update drawing to match model		FIXED MODEL TO MATCH ACTUAL PRODUCTION PART. DRAWING UPDATED AND SENT THRU VAULT APPROVALS	
Verification & Review			
Target Date 11/27/2015	Owner Downing, Eric M	Closed Date	Closed By
Details			

Actions									
Number		Owner			Target Date			Completed Date	
Details					Response				